



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18540-1
Job Sheet 189450



Part No: RBT18540-1

Job Qty: 5 ea

Part Name: Bell



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/24/19

Job Tracking No:

Due Date: 2/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT18540 Rev 3 IPP Rev A 18.03.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Omax - 1	5 pcs		2/8/19	0.00	1.00	Waterjet - Omax		dc 19/01/27
110	QC	5 pcs		2/8/19	0.00	0.00	QC2 Waterjet-3		dc 19/01/27
120	Mill Conv	5 pcs		2/8/19	0.00	1.00	NV5000-2		FL 19-2-13
130	QC	5 pcs		2/8/19	0.00	0.00	QC2-2		FL 19-2-13
140	QC	5 pcs		2/8/19	0.00	0.00	QC8		FL 19-02-14
170	Outsource	5 pcs		2/8/19	0.00	0.00	Outsource1		CT 19-02-14
175	Outsource	5 pcs		2/8/19	0.00	0.00	Outsource3		CT 19-2-27
180	Packaging	5 pcs		2/8/19	0.00	0.00	Packaging2		DP MAR 05 2019
190	QC	5 pcs		2/8/19	0.00	0.00	QC6		MAR 05 2019
200	Packaging	5 pcs		2/8/19	0.00	0.00	Packaging3-1		MLL 9-89 GA
210	QC21-SA	5 Ea		2/8/19	0.00	0.00	QC21		DAE 21 MAR 05 2019

Part Op 100 - 1-Cut as per Dwg Dwg Rev: 3 Prog Rev: 3 2-Deburr if necessary

Descriptions: 120 - 1-Machine as DWG. 2-Deburr

130 - Engrave T/N, S/N and "CAPACITY 4000LBS PROOD LOAD 6000LBS" using Marktronic engraver as per DWG

170 - 1--Issue P/O to Metcore; P/O 042561 RC 32-38 2-Bead blast 3- Certificate of Conformity is required

NOTE DROP SHIP TO FINISHER Metcore to ship directly to Groupe Altech***

175 - -Issue P/O to Groupe Altech: P/O -Cadmium plating, QQ-P-416F TYPE II, CLASS II -Color: Yellow - Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-B-1.000X6.250	4140 Steel Bar 1.000 X 6.250	2090 ft (.0598 ea)	100-Waterjet - Omax - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Omax - 1	MT-4140-B-1.000X6.250	0	1	0

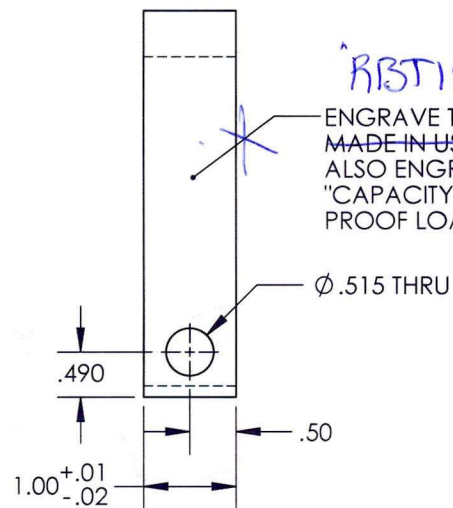
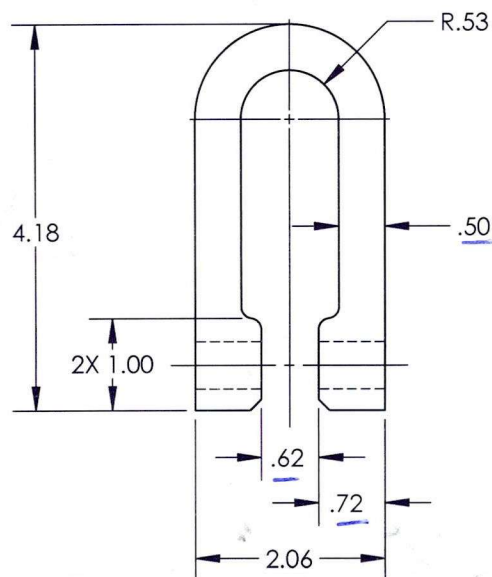
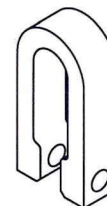
Part Specifications

Specifications could not be found.

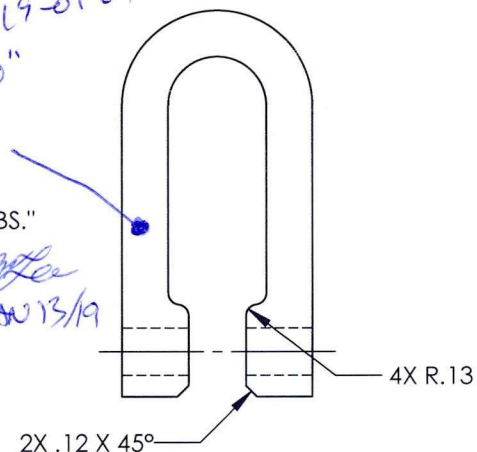
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVER
A		-1 CH'D ENGRAVE NOTE CAPACITY FROM 6,000 & PROOF LOAD FROM 12,000.	9/20/2011	RJC	DW
B		-1 ADDED MISSING DIM. R.125.	2/17/2012	RJC	GE
3	15-0192	-1 CH'D DIM WAS 1.00 IS 1.00 +.01-.02.	8/5/2015	RJC	JAG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189450415
19-0124



ENGRAVE T/N, S/N,
MADE IN USA
ALSO ENGRAVE
"CAPACITY 4000 LBS.
PROOF LOAD 6,000 LBS."



(-1)
BELL

DART AEROSPACE	
TITLE LONG RANGER LIFTING EYE	
DWG NO. R BT18540-1	REV 3
MAT'L 4140/4142	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED D Weil
.XXX ± .005	HEAT TREAT RC 32-38
.XX ± .01	FINISH CAD PLATE YELLOW
.X ± .1	SPEC QQ-P-416, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	BELL 206L
SCALE 1:2	DATE 10/22/2010 SHEET 2 OF 3

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S148462



Part: RBT18540-1

Job No: 189450

Serial No/Batch: S148462

Revision: 3

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/28/19



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042561



Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S 1R4 Canada
Phone: 866 257 6395

PO No: PO042561
PO Date: 2/11/19
Due Date: 2/25/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Overnight
Pymt Terms: Net 30

Freight Terms:

Special Comments: ** Absolutely need back for Feb. 20 **

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	189204	RBE350A93-3202-00-20	Leg 1-Issue P/O; RC 36-40 2-Bead blast 3-Material type; 4140 4- Certificate of Conformity is required	Firmed	-	2/25/19	3 pcs	0 pcs	3 pcs	\$25.00/pcs	\$75.00
2	188809	RBW109-3130-82-103-5	Extractor Rod 1-Issue P/O; RC 30-36 2-Bead blast 3-Material type; 4140 4- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER HEAT TREAT to ship directly to Groupe Altech***	Firmed	-	2/25/19	6 pcs	0 pcs	6 pcs	\$12.50/pcs	\$75.00



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PURCHASE ORDER PO042561



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	188715	RBT18560-1	1-Issue P/O to Metcore ; P/O _____ RC 45-52 ***Heat treat with expander fixture installed*** ***NOTE***REMOVE EXPANDER FIXTURES BEFORE BEAD BLASTING 2-Bead blast 3- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER Atlantic to ship directly to Groupe Altech INCLUDING RBT18560-1 EXPANDER FIXTURES NOT INSTALLED	Firmed	-	2/25/19	10 pcs	0 pcs	10 pcs	\$7.50/pcs	\$75.00
4	188785	RBE105- 14181W3-5	Extractor Bar 1-Issue P/O; _____ RC 35-40 2-Bead blast 3--Material type; 4140 4- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER HEAT TREAT to ship directly to SURFACE FINISH***	Firmed	-	2/25/19	5 pcs	0 pcs	5 pcs	\$15.00/pcs	\$75.00
5	189450	RBT18540-1	Bell 1-Issue P/O to Metcore ; P/O _____ RC 32-38 2-Bead blast 3- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER Metcore to ship directly to Groupe Altech***	Firmed	-	2/25/19	4 pcs	0 pcs	4 pcs	\$18.75/pcs	\$75.00
Grand Total:											\$375.00

DAS
68
9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042561



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 2/27/19 12:49 PM dart.tsimiklis.chrisoula

Atlantic Heat Treating (2001) Ltd

Order No.: 163296

Ship Date: 19/2/2019

Shipping Ticket

Sold To:
DART AEROSPACE LTD.
1270 ABERDEEN ST

1448

HAWKESBURY ON K6A 1K7

Ship To:
DART AEROSPACE LTD.
1270 ABERDEEN ST

160306

HAWKESBURY ON K6A 1K7

Page 1 of 1

Purchase Order Number	Packing List No	Customer Job No	Route	Carrier
PO042561				

Quantity	Part No. / Part Name / Part Description	Pounds
4	PCS MATERIAL 4140 ANNEAL AND HEAT TREAT TO 32-38RC SANDBLAST, C OF C, PRT# RBT18540-1, JOB# 189450	

Container Type	# Of Containers	Cust Cont Id	Container Type	# Of Containers	Cust Cont Id
BOX	1				

NOTICE: OUR LIABILITY IS LIMITED TO OUR INVOICE CHARGES ONLY

Shipped Complete

Quantity Shipped:

4

Pounds Shipped:

5.00

Order No.: 163296

Shipped Complete

Quantity Shipped:

4.00

Received By:

Date:

Pounds Shipped:

5.00

Sold To: DART AEROSPACE LTD.

Shipped ON: 02/19/2019

Certification

Date: 02/21/2019

Entry Date: 02/19/2019

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: PO042561

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: 4140

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
4	4 PCS MATERIAL 4140 ANNEAL AND HEAT TREAT TO 32-38RC SANDBLAST, C OF C, PRT# RBT18540-1, JOB# 189450	6.6 9-89

Insp. Type Scale Minimum Maximum Number Other

Customer Requirements:

Harden rockwell

Results:

Harden ROCKWE 32. 38. 38. TESTED AS PER SAMPLING PLAN

HEAT TREATED TO 38 RC AS PER CUSTOMER REQUEST

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY): ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER. IN SUCH EVENT A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE OF CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE AFOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformity, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater


KEAN SHEPHERD
QUALITY CONTROL
ATLANTIC HEAT TREATING 2001 LTD



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042726



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO042726
PO Date: 2/27/19
Due Date: 3/6/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	188809	RBW109-3130-82-103-5	Extractor Rod -Issue P/O; _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 4140 -Certificate of Conformity is required	Firmed	-	3/6/19	6 pcs	0 pcs	6 pcs	\$12.00/pcs	\$72.00
2	189450	RBT18540-1	Bell -Issue P/O; _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 4140 -Certificate of Conformity is required	Firmed	-	3/6/19	4 pcs	0 pcs	4 pcs	\$5.00/pcs	\$20.00
Grand Total:											\$92.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042726



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 2/27/19 7:51 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(017205-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

017205- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
28-Feb-2019		Jessie Boisvert		042726				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBW109-3130-82-103-5 Rev.	RBW109-3130-82-103-5 01 -ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours ASTM B633 TYPE 2 SC2	ZINC CH	6	6	0	0	0
2	RBT18540-1 Rev.	RBT18540-1 01 -ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours ASTM B633 TYPE 2 SC2	ZINC CH	4	4	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

JB

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.